

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

154903

Tuesday, January 03, 2017 3:14:41 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/10/2017 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 1/16/2017 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

130

0.08

Small Fab

Memo

INSTALL HELI-COIL AS PER DRAWING

Small Fab

QC5- Inspect part completeness to step on W/O

0.00

140

0.03

QC

Memo

Quality Control

Identify as per dwg & Stock Location: WAO 0.00

0.00

150

0.02

Packaging

Memo

Packaging

LOCATION: WA002

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Work Order ID 154903

Tuesday, January 03, 2017 3:14:41 PM

154903

Page 3

Item ID: D4667-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Armrest Stud Assembly
Start Date: 1/10/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 1/16/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.17							
Quality Control									

DAS
21
9-89
JAN 16 2017


JAN 12 2017

DQA: _____ Date: _____



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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Root Cause		FAULT CATEGORY			
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

Tuesday, January 03, 2017 3:14:45 PM

Work Order ID: 154903

154903

Parent Item: D4667-041

D4667-041

Parent Item Name: Armrest Stud Assembly

Start Date: 1/10/2017

Required Date: 1/16/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12/06/11 as per dwg rev.PA1 JFS verf: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4130NR0.750

Purchased

No

100

f

15.8000

0.12

1.263158

DAS

M4130NR0 750

44

9-89

17-01-05

4130 steel RD bar .750"

Location

Loc Qty

Loc Code

MAT032

15.799968

m132798

3.799968

1.33

m135856

12

MS21209-F415

Purchased

No

130

Each

34.0000

1

10

MS21209-F415

DAS

30

9-89

JAN 10 2017

Heli-Coil

Location

Loc Qty

Loc Code

ST296

34

M133640

34

10

DQA: _____ Date: _____



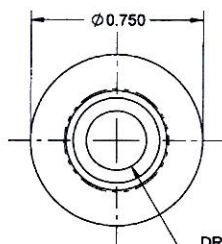
WORK ORDER NON-CONFORMANCE / UPDATE

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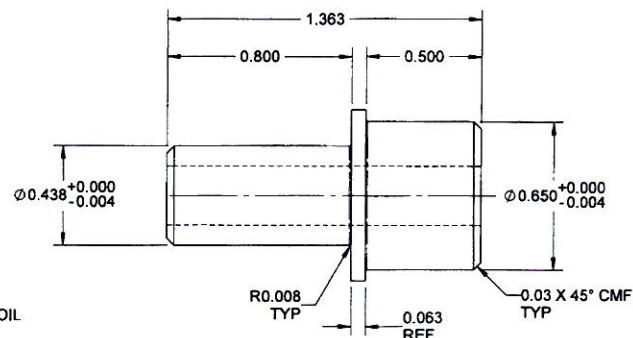
Work Order update only ☐

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OTHER : ☐					

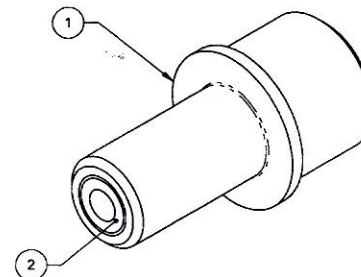
ITEM	QTY	P/N	DESCRIPTION
	X	D4667-041	ARMREST STUD ASSEMBLY
1	1	D4667-1	ARMREST STUD
2	1	MS21209-F415	HELICOIL, LOCKING



DRILL THRU $\varnothing 0.261$
TAP FOR 0.250-28 HELICOIL
0.45 DP



D4667-1 ARMREST STUD



D4667-041 ARMREST STUD ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154903

JAN 03 2017

NOTES:

- 1) MATERIAL -041: N/A
-1: AISI 4130N ROUND BAR
PER MIL-S-6758 OR AMS 6348/6370/6528
REF M4130N-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

RELEASED
2012-07-09
4 PER 2012-06-06

REV.	NEW ISSUE	DESCRIPTION	AJS	12.06.12
DESIGN	AJS			
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	12.06.12			

DESIGN	AJS	DESCRIPTION	AJS	12.06.12
DART AEROSPACE LTD				
HAWKESBURY, ONTARIO, CANADA				
DRAWING NO.	D4667			
TITLE	ARMREST STUD ASSEMBLY			
SCALE	NTS			
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD				

